

Work Order ID 83858

83858

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Work Order ID 83858

83858

Page 1

Item ID: D3278-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support Assembly

Start Date: 26/04/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/04/26* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

0.00

120

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278.***DO NOT TIGHTEN BOLTS***Identify as D3278-041

40x

12/06/20

40

12/06/20

40x

12/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QANCRWO RevE

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NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QANCRWO RevE

Picklist Print

April-26-12 2:26:46 PM

Page 1

Work Order ID: 83858

83858

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1 *D3278-1* Support		Manufactured	No			100	Each	21.0000	1	40	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		21							
				73412		1							
				80579		20							
D3278-2 *D3278-2* Support		Manufactured	No			100	Each	21.0000	1	40	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		1							
				74879		1							
				GA		20							
				80580		20							
D3278-3 *D3278-3* Spacer		Manufactured	No			100	Each	31.0000	1	40	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		31							
				70984		2							
				77061		14							
				80166		15							

EP 2/06/20
B83870
400
EP 2/06/20
B83877
400
EP 2/06/20
B84016
400

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Work Order ID: 83858

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 40.00

Required Qty: 40.00

MS21042L4

Purchased

No

100

Each

5,796.000

2

80

MS21042L4

**

Nut

Location

Loc Qty

Loc Code

ST300

5796

116188

5

119017

4

119075

787

121011

2000

121444

3000

AN4-13A

Purchased

No

120

Each

969.0000

2

80

AN4-13A

**

Bolt

Location

Loc Qty

Loc Code

ST357

969

119449

39

120187

19

120422

11

120770

400

121162

500

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

10.0000

4

160

AN960JD416

**

Washer

Location

Loc Qty

Loc Code

ST351

10

116289

10

SP 12/06/20

80
SP 12/06/20
M122063 22x
M121652 58x
80x

SP 12/06/20

SP M121011 118x
SP 118x
M121912 42x

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 40.00

Required Qty: 40.00

D2230-1 Manufactured No

120 Each 30.0000 2 80

D2230-1

Lug

**

EP 12/06/20
384135
8000

Location

Loc Qty

Loc Code

ST	4	
78596	4	
ST480	26	
67826	6	
70974	3	
80008	17	

MS20426AD3-6 Purchased No

120 Each 4,697.000 4 160

MS20426AD3-6

Rivet

**

EP 12/06/20
160

Location

Loc Qty

Loc Code

ST316	4697	
105055	107	
116289	1974	
120123	2616	

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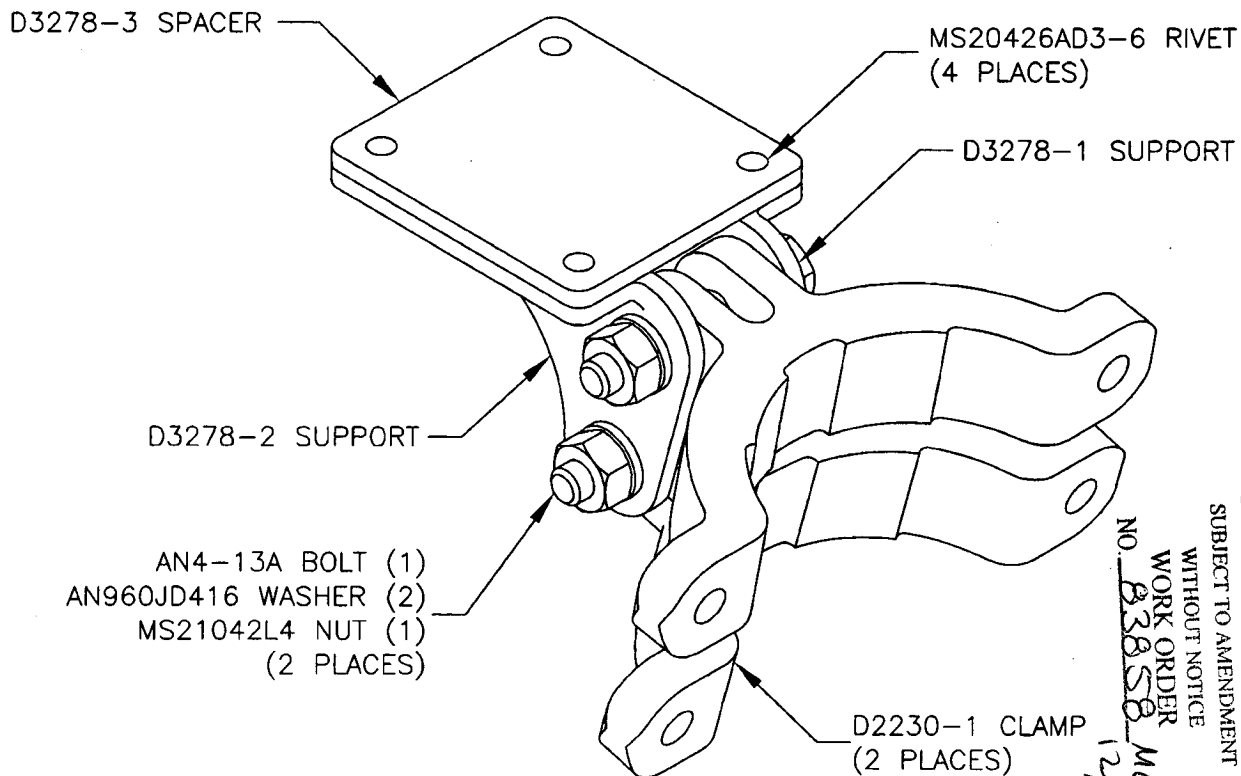
NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07 08 08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *83858* *MCS*
12/04/26

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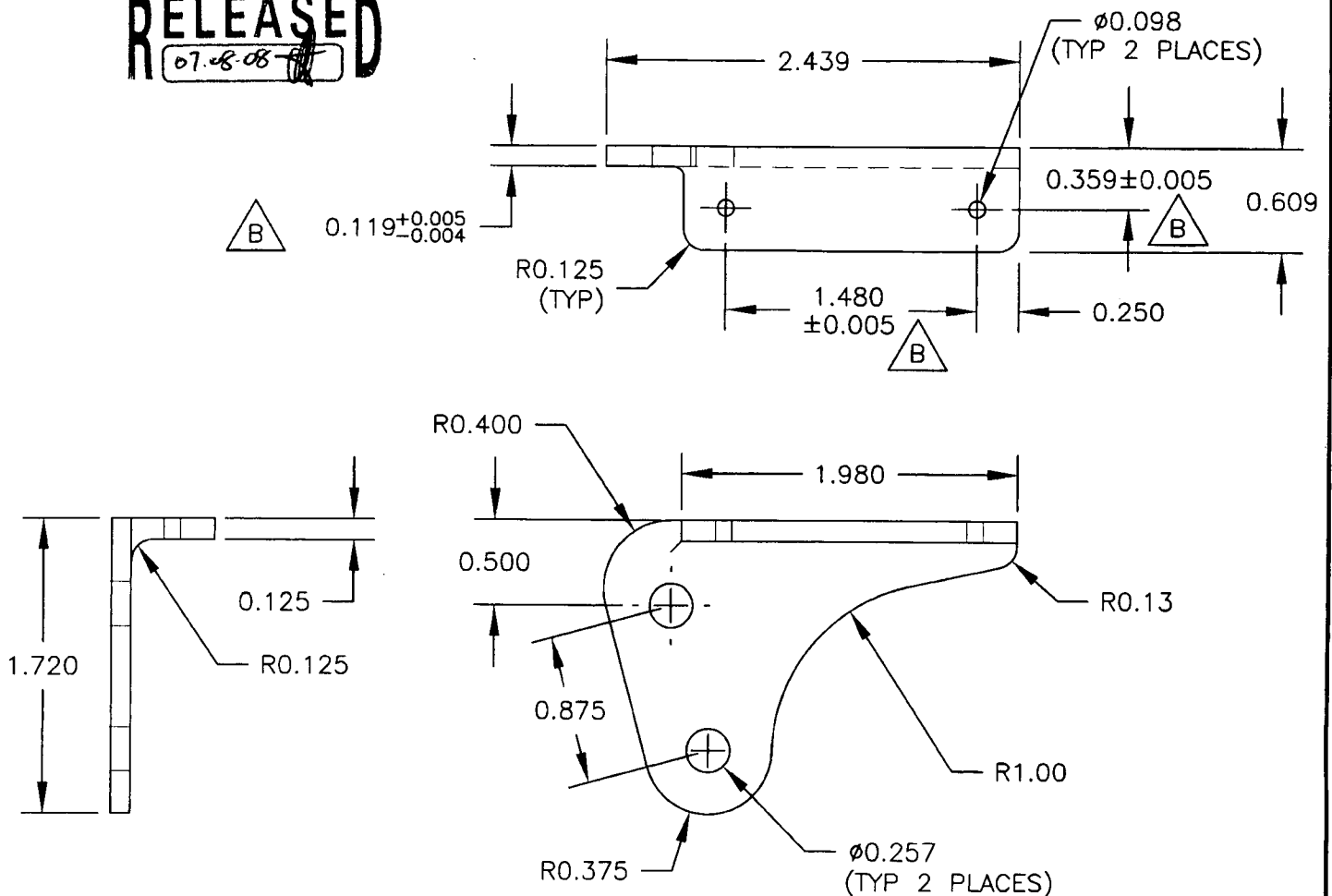
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN 97	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

03850

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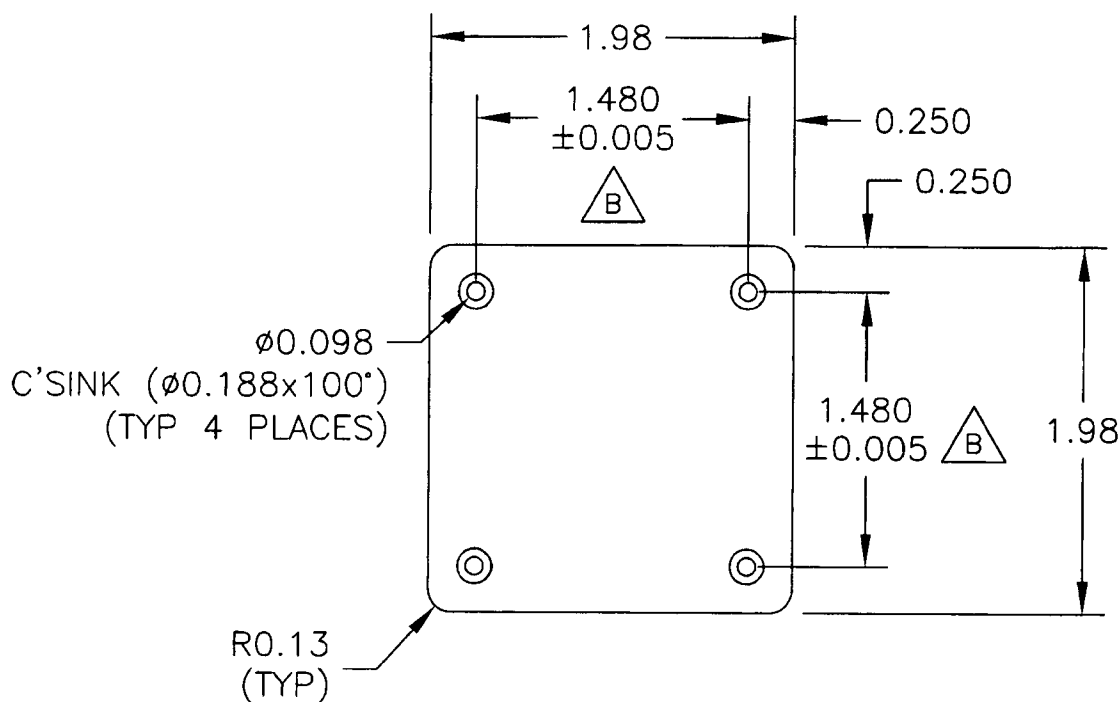
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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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